

*Rush*

Work Order ID 112179

January-30-14 11:16:23 AM

\*112179\*

Page 1

Item ID: D3536-23

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Gasket Center

Stop

\*NS2\*

Start Date: 1/30/14

Start Qty: 16.00

\*16\*

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 16.00

\*16\*

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 14-01-30

Tooling:

Date:

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3536	Rev A	

100 0.00

\*100\* FLOW WATER JET 16 0 Jm14-02-20  
Waterjet Memo 0.00  
FLOW CNC Waterjet 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-  
neo .063" Debur if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

\*110\* QC Memo 0.00 16 0 Jm14-02-20  
Quality Control

120 QC8- Inspect parts - second check 0.00 DAS

\*120\* QC Memo 0.00 27 969 16  
Quality Control M12121

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_

### DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

### AGAINST DEPARTMENT/PROCESS

Skid-tube   
 Machining   
 Thermoforming   
 Large Fab

Crosstube   
 Small Fab   
 Finishing   
 Composite

Water Jet   
 Prod. Eng. Coor.   
 Rec/Store/Packaging   
 Supplier

Engineering   
 Quality   
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General				
Bending	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Set-up
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Weld
Cuffs	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Wrong Stock Pulled
Crushing	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	
Heat Treat	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	
Inspection Strip in Tube	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>	
Marks/Chatter	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>	
Turning Sequence	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>	Other

**Work Order ID 112179****\*112179\***

Page 2

January-30-14 11:16:23 AM

Item ID: D3536-23

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Gasket Center

Stop

**\*NS2\***

Start Date: 1/30/14

Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

130

Identify as per dwg & Stock Location: FP-001**\*130\***

Packaging

Packaging

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

16 4 14 02 21

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Quality Control

0.00

14-02-2414-02-24

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

### DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

### AGAINST DEPARTMENT/PROCESS

Skid-tube   
 Machining   
 Thermoforming   
 Large Fab

Crosstube   
 Small Fab   
 Finishing   
 Composite

Water Jet   
 Prod. Eng. Coor.   
 Rec/Store/Packaging   
 Supplier

Engineering   
 Quality   
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General				
Bending	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Set-up
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Weld
Cuffs	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Wrong Stock Pulled
Crushing	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	
Heat Treat	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	
Inspection Strip in Tube	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>	
Marks/Chatter	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>	
Turning Sequence	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>	

# Picklist Print

January-30-14 11:16:23 AM

Page 1

Work Order ID: 112179

Parent Item: D3536-23

Parent Item Name: Gasket Center

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	44.1000	1.3365	23.76	24.	Jm 14-02-20	

Location	Loc Qty	Loc Code
MAT052	44.1	
M126546	44.1	

128266

128266

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

## Work Order update only



Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS																																						
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>																																					
Part No. _____																																												
NCR No. _____																																												
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																																		
Design <input type="checkbox"/>	Doc/Data <input type="checkbox"/>	Equip/Tooling <input type="checkbox"/>	Handling/Pre <input type="checkbox"/>	Material <input type="checkbox"/>	Operator <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Process <input type="checkbox"/>	Supplier <input type="checkbox"/>	Training <input type="checkbox"/>	Transport <input type="checkbox"/>																																		
Unapproved <input type="checkbox"/>																																												
FAULT CATEGORY																																												
Landing Gear			General																																									
Bending <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	Cracks <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Crushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Inspection Strip in Tube <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Bend <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Burrs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Countersink <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Drawing <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Finish <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Grain <input type="checkbox"/>	Hardware <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Misread <input type="checkbox"/>	Off-set <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Weld <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Other <input type="checkbox"/>

DART AEROSPACE LTD		Work Order:	112179
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

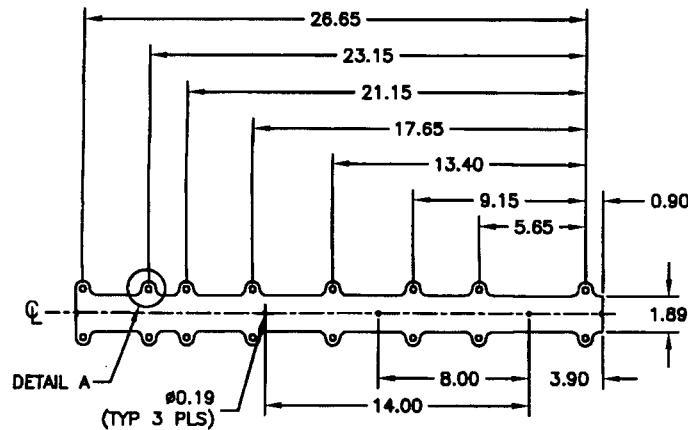
First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85"	—		T	JAmo 6
48.20	+/-0.030	48.20"	—		T	
44.70	+/-0.030	44.70"	—		T	
39.31	+/-0.030	39.31"	—		T	
33.92	+/-0.030	33.92"	—		T	
28.53	+/-0.030	28.53"	—		T	
23.14	+/-0.030	23.14"	—		T	
17.75	+/-0.030	17.75"	—		T	
14.25	+/-0.030	14.25"	—		T	
9.50	+/-0.030	9.50"	—		T	
4.75	+/-0.030	4.75"	—		V	JAmo 1
8.00	+/-0.030	8.00"	—		V	
16.00	+/-0.030	16.00"	—		T	
24.00	+/-0.030	24.00"	—		T	
32.00	+/-0.030	32.00"	—		T	
39.00	+/-0.030	39.00"	—		T	
48.00	+/-0.030	48.00"	—		T	
0.30	+/-0.030	0.30"	—		V	
0.30	+/-0.030	0.30"	—		V	
1.89	+/-0.030	1.89"	—		V	
Ø0.19	+0.005/-0.001	0.19"	—		V	

DAS

Measured by:	Jm	Audited by:	27	Prototype Approval:	N/A
Date:	14-02-20	Date:	14/2/20	Date:	N/A

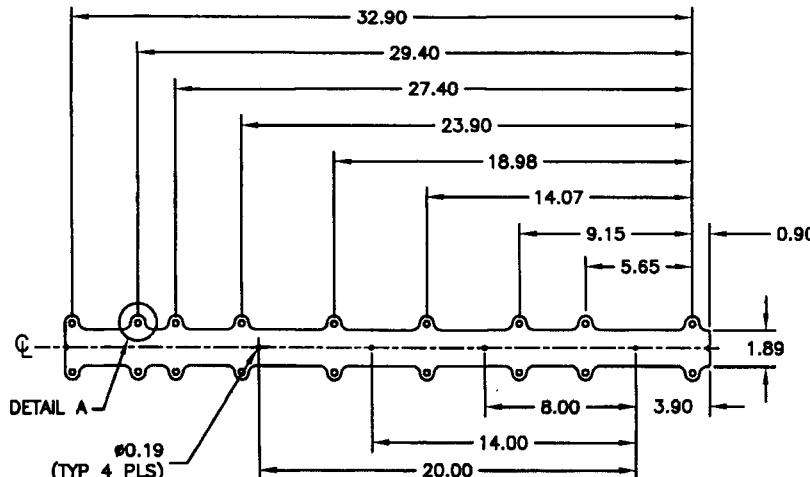
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	JAmo



**D3536-11 GASKET**

09.02.12-  
RELEASED

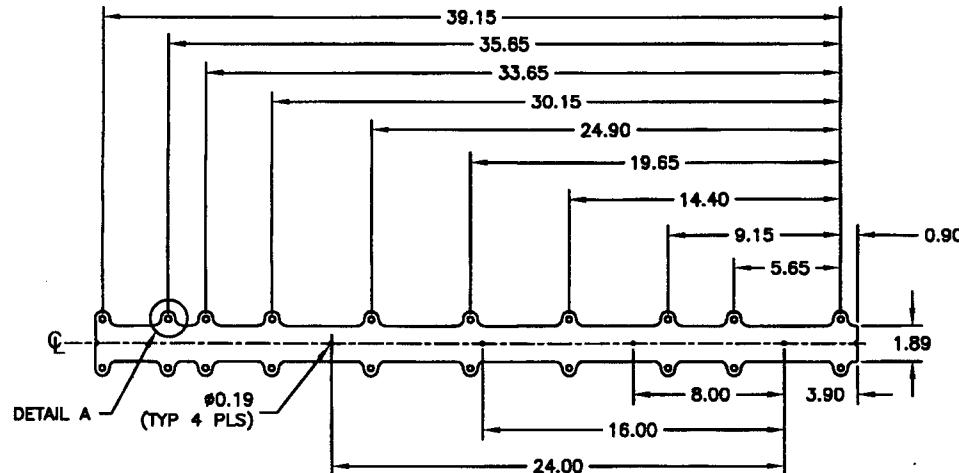
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>CB</b>	<b>CB</b>	PORT HADLOCK, WA
<i>PH</i>	<i>PH</i>	DRAWING NO.
06.10.25		06.10.25
A	06.10.25	NEW ISSUE



**D3536-13 GASKET**

**NOTES**

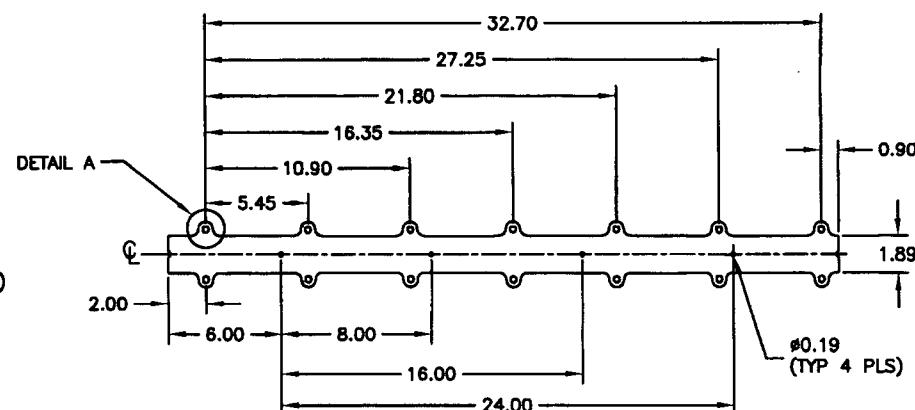
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\text{\textcircumflex}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-15 GASKET

07.02.12  
RELEASER  
DART

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A
		SHEET 2 OF 6
		SCALE <b>1:10</b>



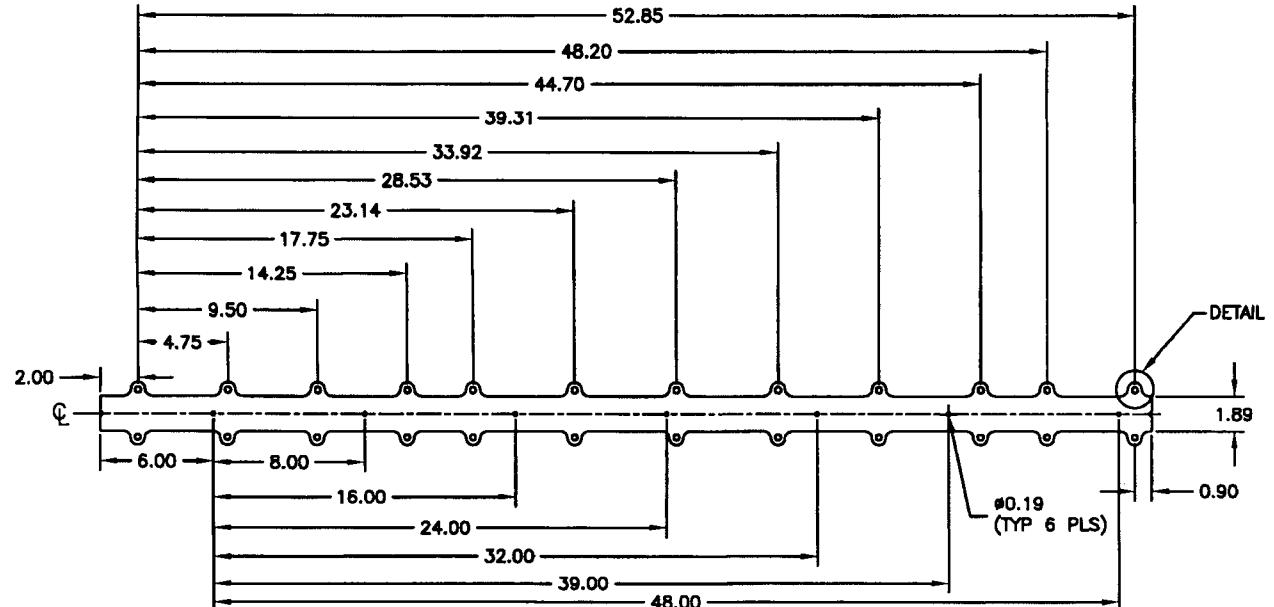
D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S-063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**NOTES**

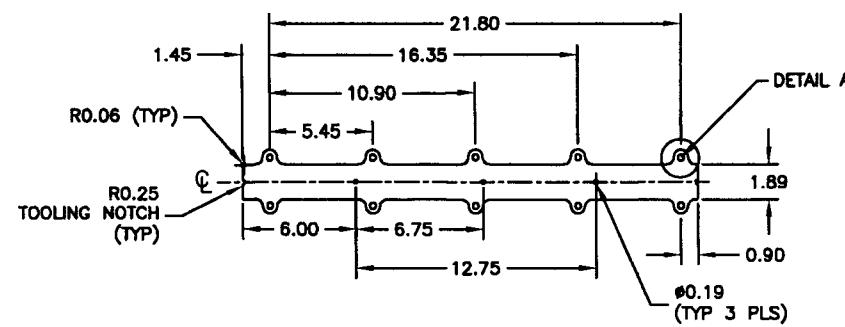
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



**D3536-23 GASKET**

07-02-02  
H

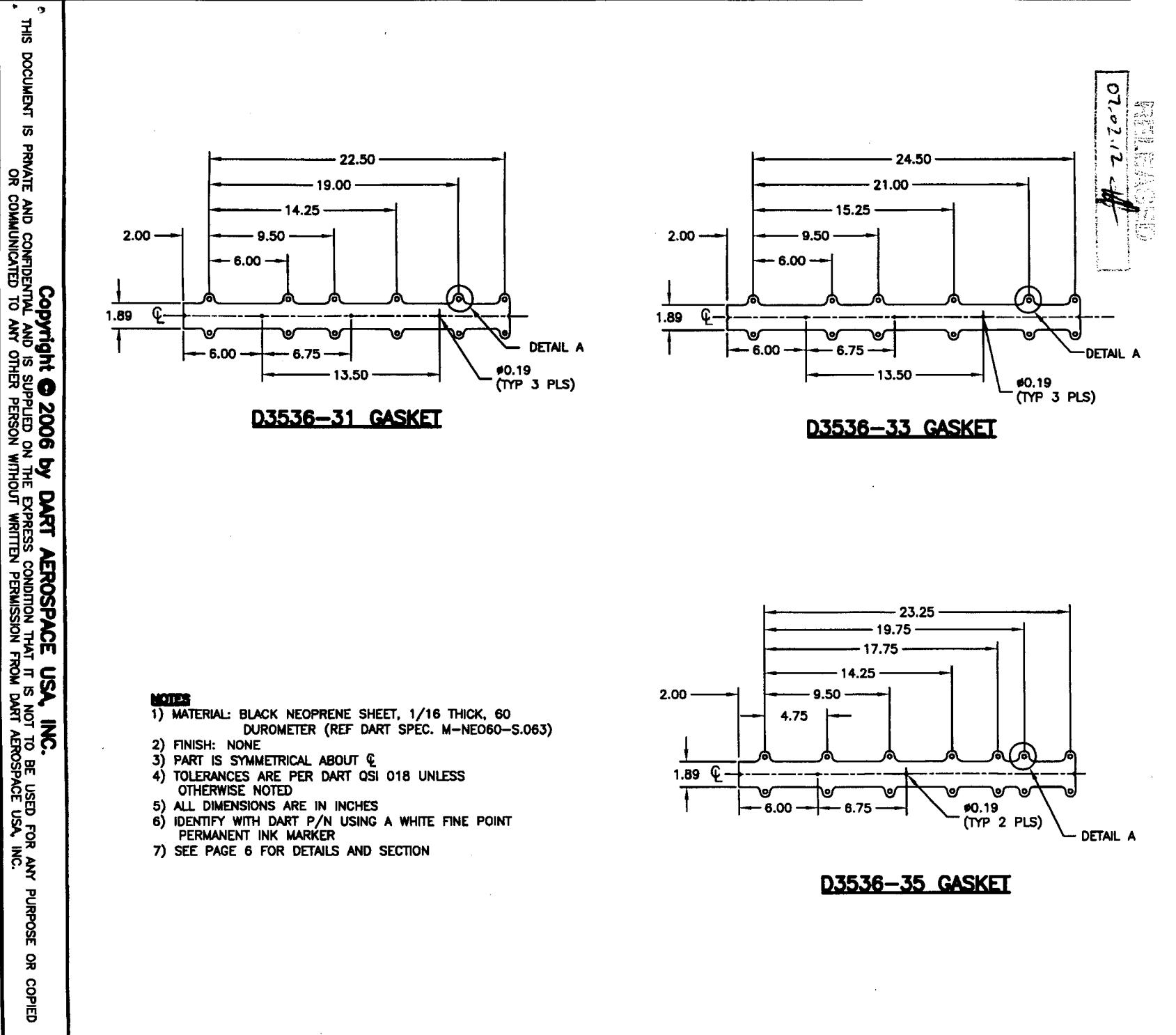
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>CB</b>	<b>CB</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<b>PH</b>	<b>W</b>	D3536
DATE	TIME	SCALE
06.10.25		1:10

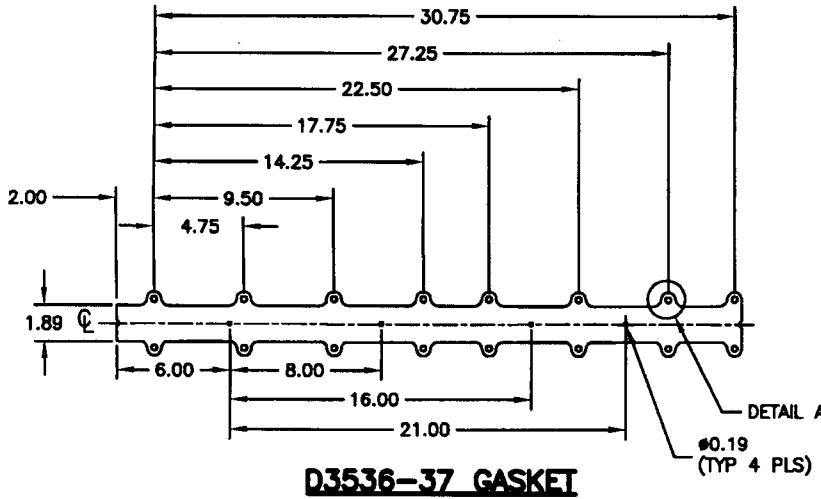


**D3536-25 GASKET**

**DART**

REV. A  
SHEET 3 OF 6  
SCALE 1:10

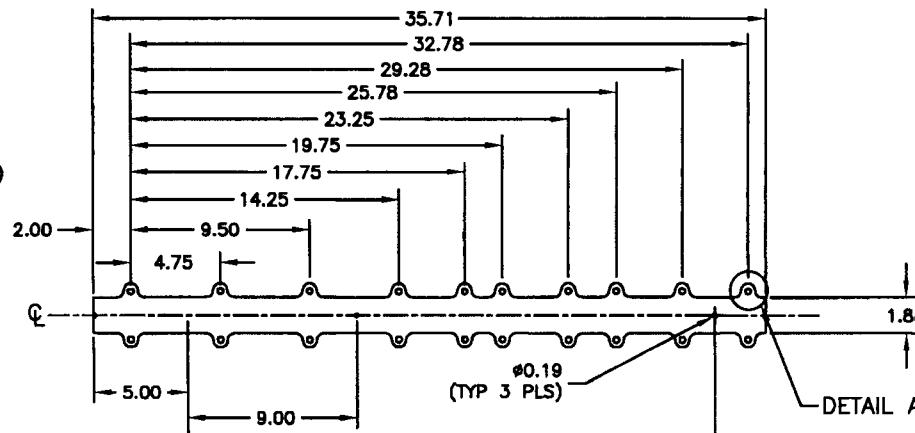




07.02.02  
CH

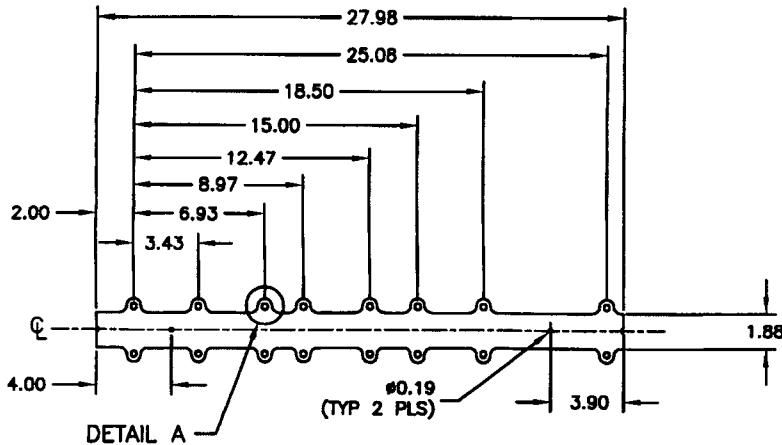
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SCALE <b>1:10</b>
REV. A	SHEET 5 OF 6	



**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



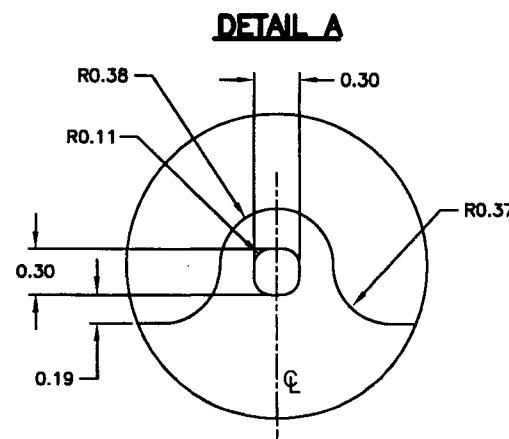
D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 6 OF 6 SCALE <b>1:10</b>



07.02.12 *[Signature]*